

Work Order ID 67872

Monday, April 04, 2011 7:58:28 AM

**PRELIMINARY ISSUE**

Page 1

Item ID: D4349-11

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Block

Start Date: 4/4/2011 Start Qty: 2.00



Cust Item ID:



Required Date: 4/5/2011 Req'd Qty: 2.00



Customer:

Reference:

11-03-04

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4349

PA2

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg
Dwg Rev: *PA2*
Prog Rev: *PA2*
2-Deburr if necessary*11-4-4**(3)*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*11-4-4**(3)*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

11-04-04

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Page 2

Item ID: D4349-11

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Item Name: Block

Start Date: 4/4/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Small Fab

Small Fab

NC BRAKE

Memo

C'sink hole as per dwg

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150



Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

N/A Jan 11-04-04

N/A Jan 11-0

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Page 3

Item ID: D4349-11

Accept

Revision ID: PRELIM

Item Name: Block

Start Date: 4/4/2011 Start Qty: 2.00

Required Date: 4/5/2011 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W10405

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

Pulled on D4349-01/B
67871 RD1370

Picklist Print

Page 1

Monday, April 04, 2011 7:58:25 AM

Work Order ID: 67872



Parent Item: D4349-11



Parent Item Name: Block


Start Date: 4/4/2011

Required Date: 4/5/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.03.17 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NS.100  4130 Sheet .100		Purchased	No			100	sf	0.0000	0.0089	0.018737			

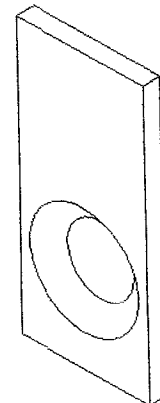
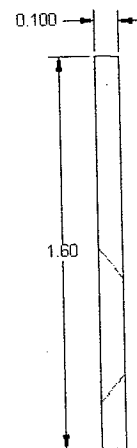
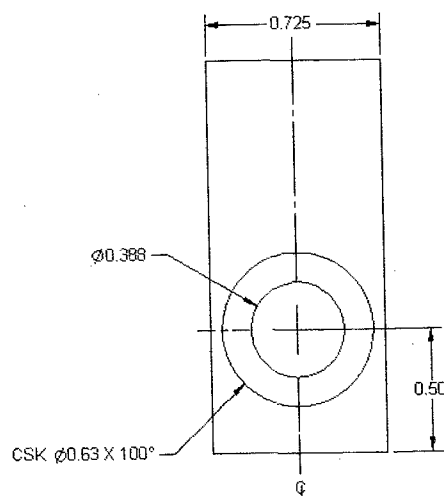


B 11-4-4

4130 SHEET .125

103505

(3)






D4349-11 BLOCK

w/o 67872

PRELIMINARY ISSUE

11.03.03

- NOTES:
- 1) MATERIAL: AISI 4130N STEEL BAR
DART SPEC M4130N-B
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.03 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PAS
MFG. APPR.		D4349	SHEET 9 OF 10
APPROVED		TITLE	SCALE
DE APPR.		SHELF	NTS
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